

Work Order ID 60232

Tuesday, June 29, 2010 11:43:04 AM



Page 1

Item ID: D3535-35

Revision ID:

Item Name: Wearshoe

Start Date: 6/29/2010 Start Qty: 10.00

Required Date: 7/6/2010 Req'd Qty: 10.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:



Date: 10-29

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 .040

Memo

0.00

B 10-7-07

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

B 10-7-07

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

Solvag

X12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60232

Tuesday, June 29, 2010 11:43:04 AM



Page 2

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/29/2010

Start Qty: 10.00



Cust Item ID:

Required Date: 7/6/2010

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

NC BRAKE

Memo

0.00

1-Deburr if necessary □ 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. □ 3-Identify as D3535-35.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/08/09

X12

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11/12/08

Memo

0.00

START TIME: 1:00pm □ OVEN TEMPERATURE:
1:30pm □ FINISH TIME: 3:00pm

10/08/11

X12 9

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 60232

Tuesday, June 29, 2010 11:43:04 AM



Page 3

Item ID: D3535-35

Accept



Setup

Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/29/2010

Start Qty: 10.00



Cust Item ID:

Required Date: 7/6/2010

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

m 10 08 11 12

170



Packaging

Packaging

Identify as per dwg & Stock Location: *f1218*

0.00

ll 10/08/11

x12 Ø

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

*10/08/12 JJ
mf
10-8-11*

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 11:43:08 AM

Page 1

Work Order ID: 60232



Parent Item: D3535-35



Parent Item Name: Wearshoe

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	69.9836	0.8022	8.444211		8.7 	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	66.1278	
	66.1278	
114574		
MAT20	3.8558	
112885	2.7475	
113062	1.1083	

114574

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40232
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-7-07	Date:	10/08/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

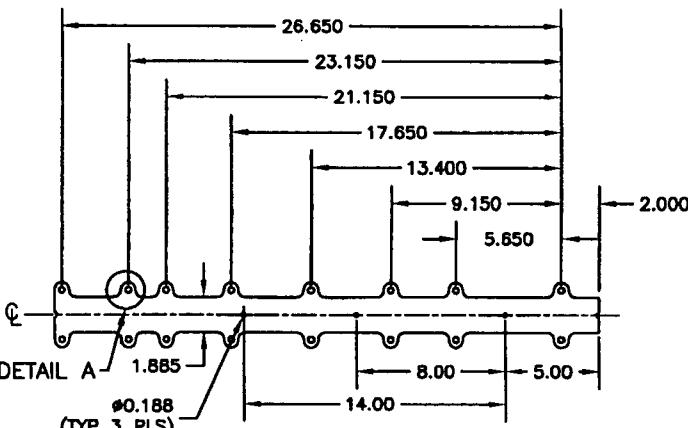
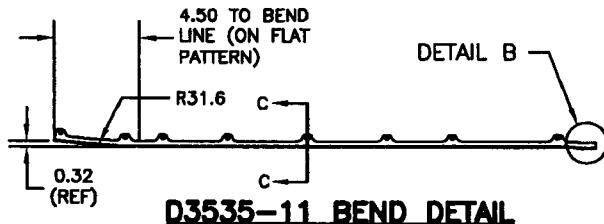
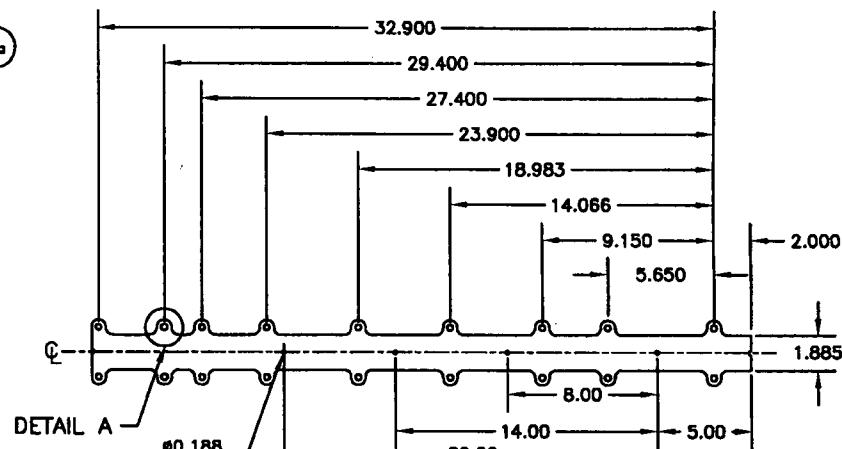
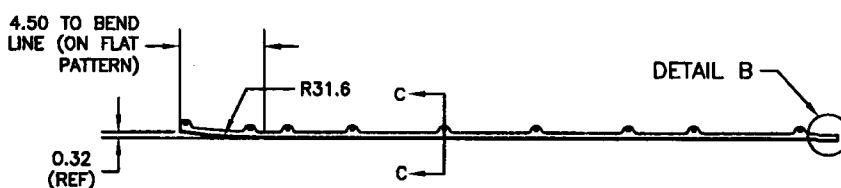
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PT	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>MM</i>	<i>MM</i>	D3535
DATE		SHEET 1 OF 7
07.04.17	06.10.25	1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

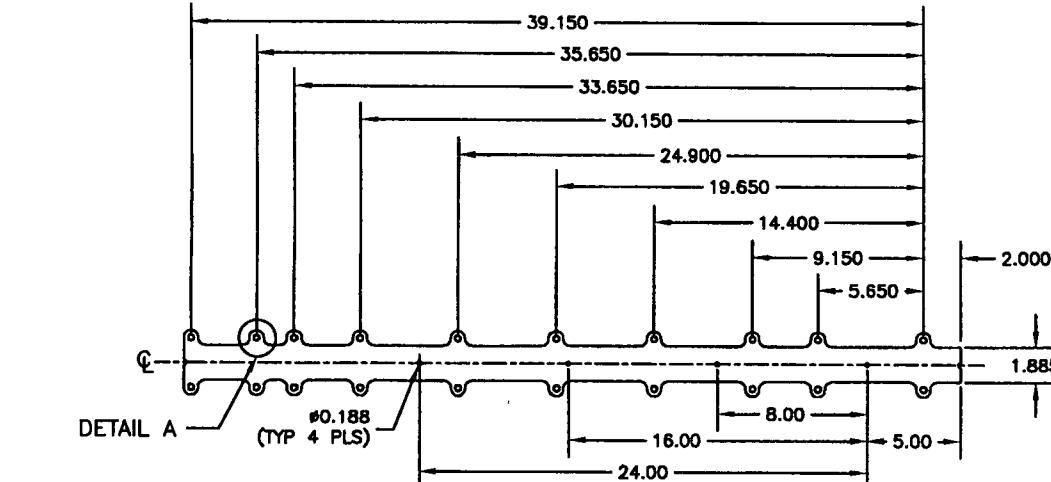
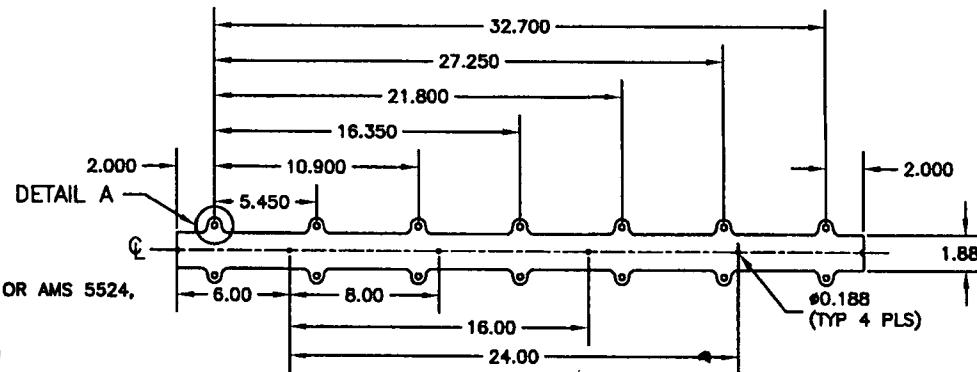
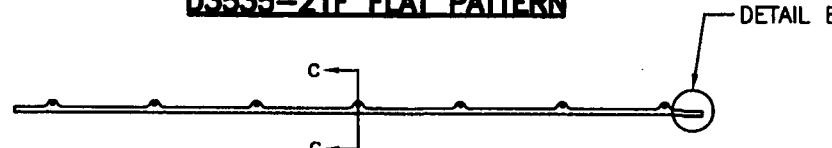
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
07.04.24**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
 - PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - ALL DIMENSIONS ARE IN INCHES
 - BREAK ALL SHARP EDGES TO 0.010 MAX
 - IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - SEE PAGE 7 FOR DETAILS AND SECTION
- W6 60232*

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED H	APPROVED H	DRAWING NO. D3535
DATE 07.04.17	DATE 07.04.17	TITLE WEARSHOE
		REV. B SHEET 2 OF 7 SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

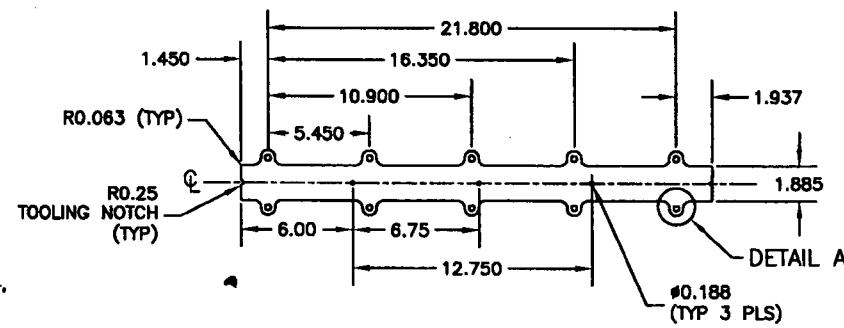
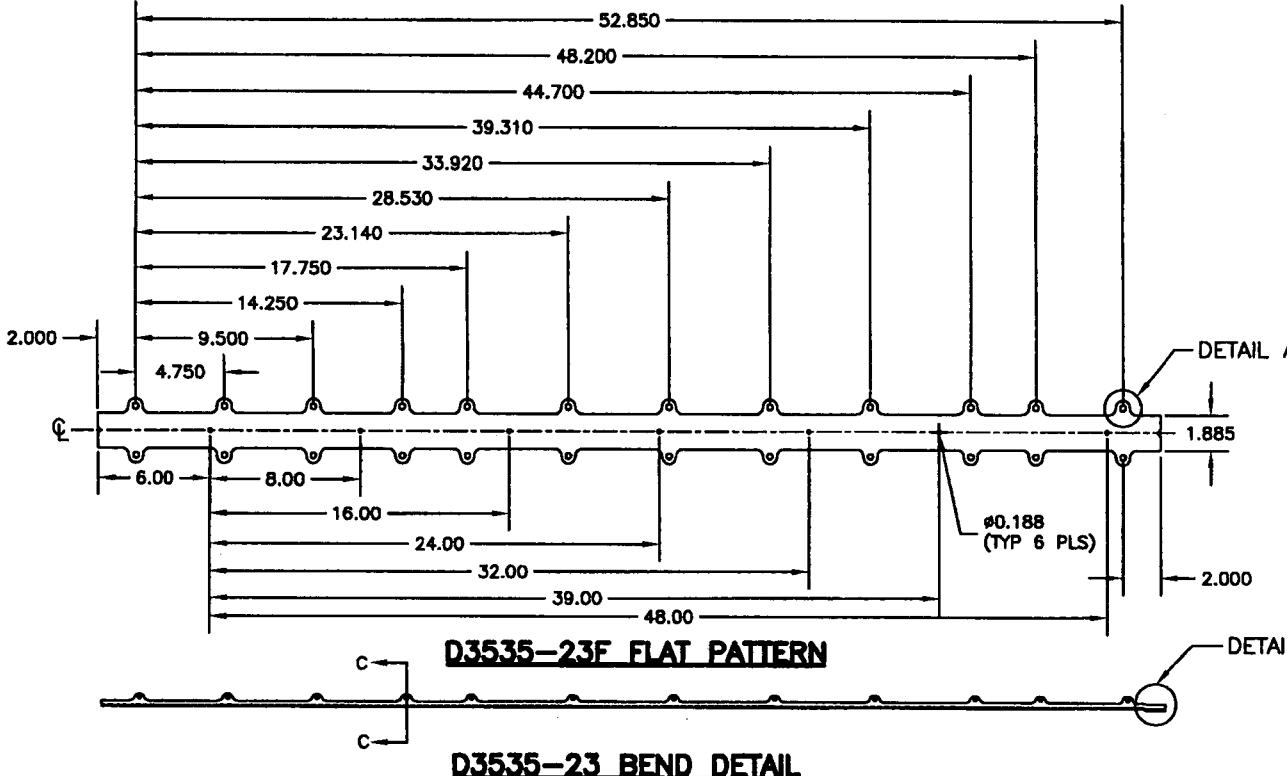
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN C.B	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

REV. B
SHEET 3 OF 7
SCALE
1:10

RELEASED
07 04 24**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION
- Wb (EB23)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

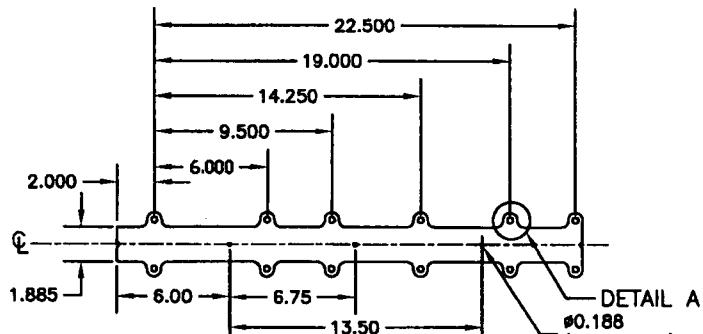
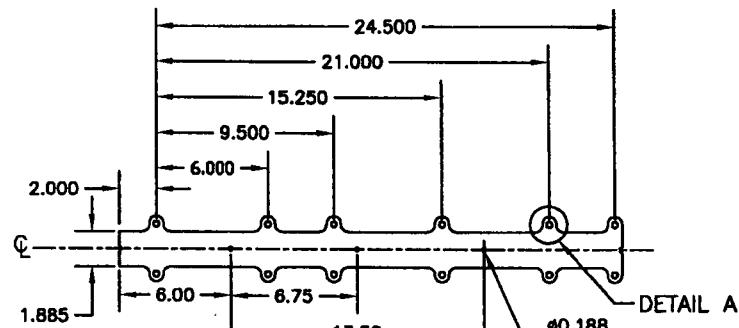
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN C.B	DRAWN BY <i>MH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>MH</i>	APPROVED <i>MH</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7 SCALE 1:10

RELEASED
07.04.24
MH

**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION
- W6 60233*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

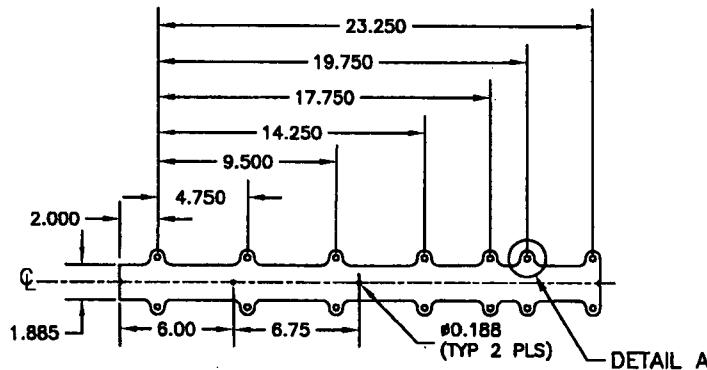
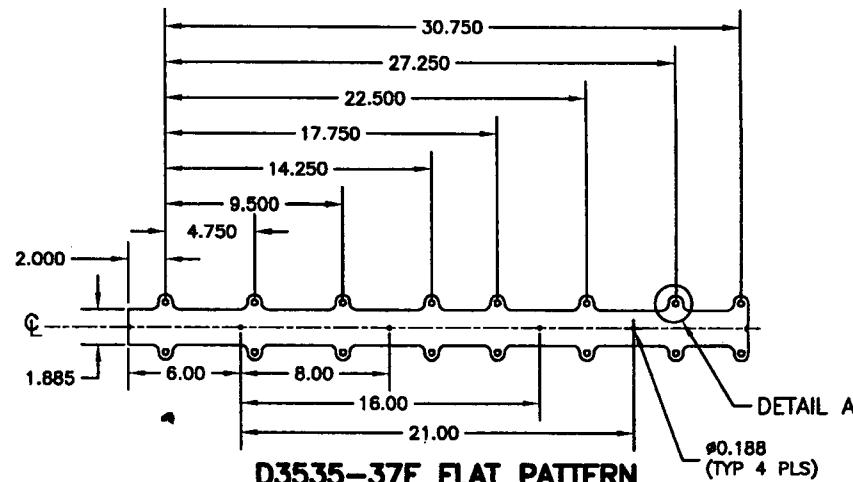
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
07.04.14

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION
- wb 6023*

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. B
C.B	<i>MH</i>			
CHECKED	<i>MH</i>	APPROVED <i>MH</i>	DRAWING NO. D3535	
DATE	<i>MH</i>		TITLE WEARSHOE	SHEET 5 OF 7
07.04.17				SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

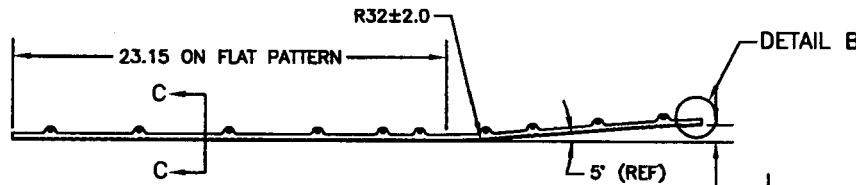
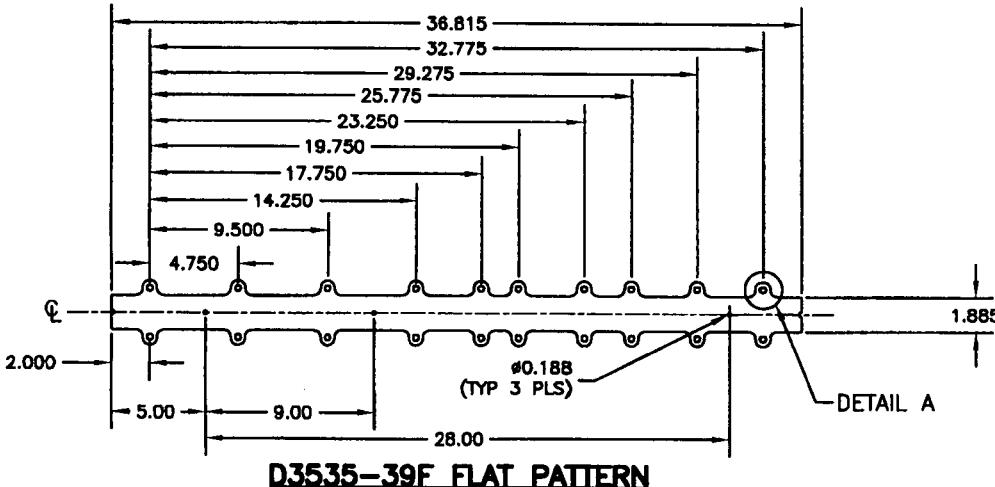
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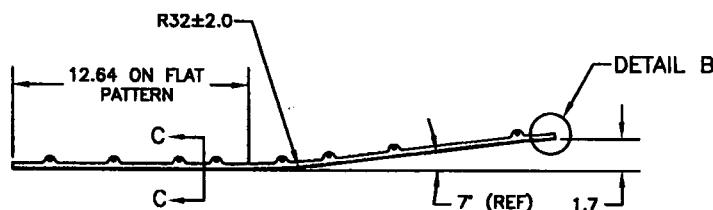
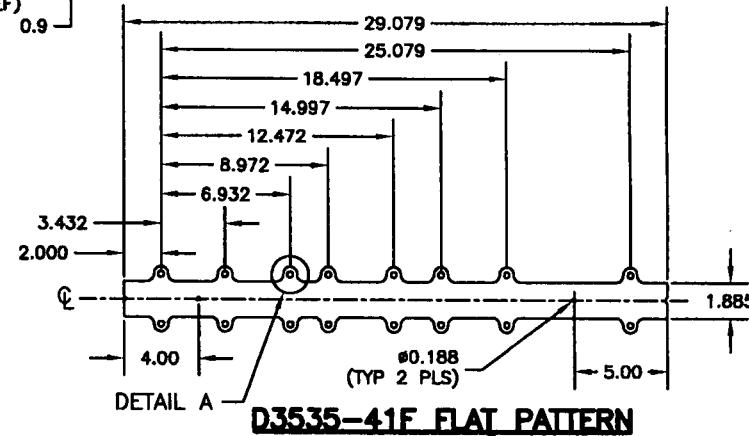
DART

DESIGN C.B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MM	APPROVED MM	DRAWING NO. D3535
DATE 07.04.17	TIME WEARSHOE	SCALE 1:10

RELEASED
07.04.24



D3535-39 BEND DETAIL



D3535-41 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5613 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION
- w/6 60230*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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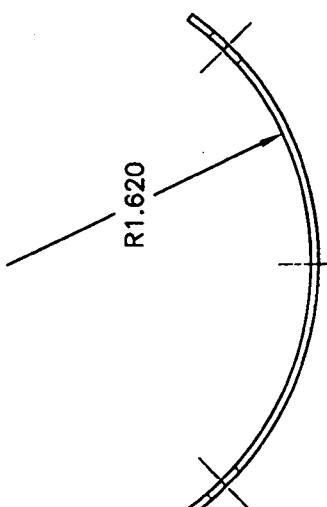
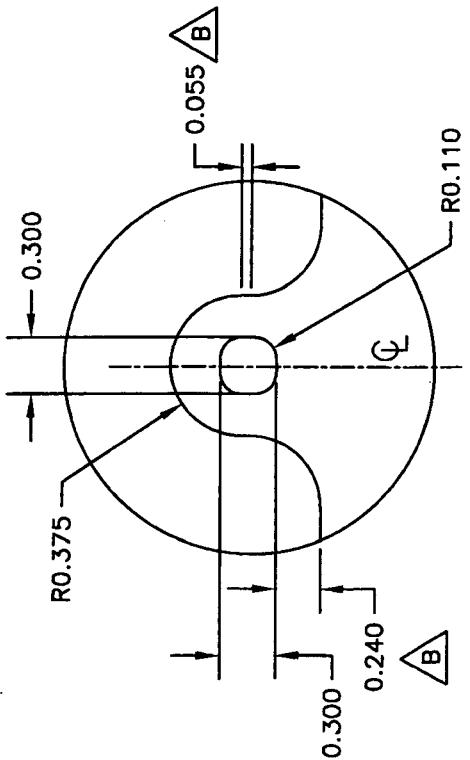
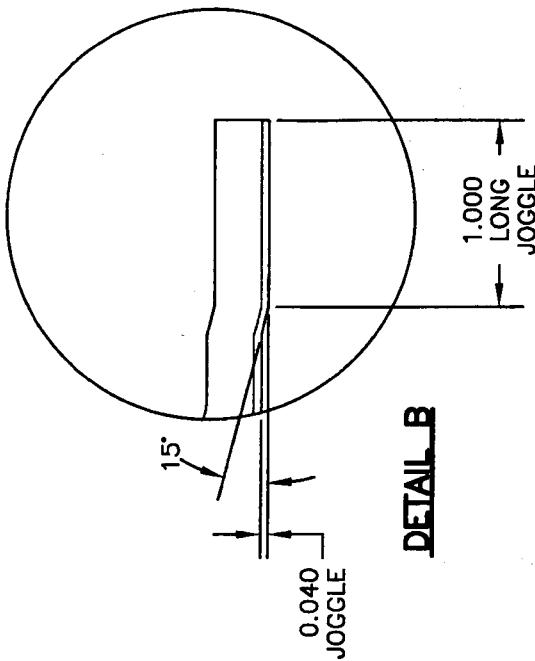
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED ✓	APPROVED ✓	DRAWING NO. D3535
DATE 07.04.17	TITLE	SCALE 1:1

RELEASED

07.04.24 ~~✓~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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